

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 32332  
Estimate Number : 12854  
P.O. Number : N/A  
This Issue : 5/14/2007 S.O. No. : N/A  
Prsht Rev. : NC  
First Issue : N/A Type : SMALL / MED FAB  
Previous Run : N/A  
Written By :  
Checked & Approved By : 07.05.14  
Comment : est rev A 07.05.10 new issue EC

Drawing Name : HARNESS ASSEMBLY

Part Number : D412702101B

Drawing Number : ICA D412-702 P.79

Project Number : N/A

Drawing Revision : D

Material : N/A

Due Date : 5/15/2007

Qty: ~~1~~ Um: Each

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
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1.0 DC DOCUMENT CONTROL

Comment: DOCUMENT CONTROL  
type labels per PPP D412-702-101B CHG001

|     |        |         |
|-----|--------|---------|
| 2.0 | D35737 | ADAPTER |
|-----|--------|---------|

Comment: Qty.: 1.0000 Each(s)/Unit Total: 9.0000 Each(s)  
ADAPTER  
batch: B31864-1

3.0 D3579046 SHOULDER HARNESS RH

Comment: Qty.: 1.0000 Each(s)/Unit Total: 9.0000 Each(s)  
SHOULDER HARNESS RH  
batch: B 32115

4.0 K62 CLIP

Comment: Qty.: 1.0000 Each(s)/Unit Total: 9.0000 Each(s)  
CLIP: M104426  
batch:

|     |             |       |
|-----|-------------|-------|
| 5.0 | MS24693S272 | Screw |
|-----|-------------|-------|

Comment: Qty: 4.0000 Each(s)/Unit Total: 36.0000 Each(s)  
Screw  
batch: M 8967 25X-

Date: Monday, 5/14/2007 7:13:47 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HARNESS ASSEMBLY

Job Number: 32332

Part Number: D412702101B

Job Number:



Seq. #: Machine Or Operation: Description:

6.0 AN960JD10LL Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 36.0000 Each(s)  
Washer  
batch: M11763

7.0 MS21042L3 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 36.0000 Each(s)  
Nut  
batch: M104215

8.0 D35693 DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total: 9.0000 Each(s)  
DECAL  
batch: B 32086

✓ ml 07/05/17

9.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg ICA D412-702 p.79

ml

ml 07/05/17

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2005.17 (2)

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-101B CHG001

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

07/05/17 (2)

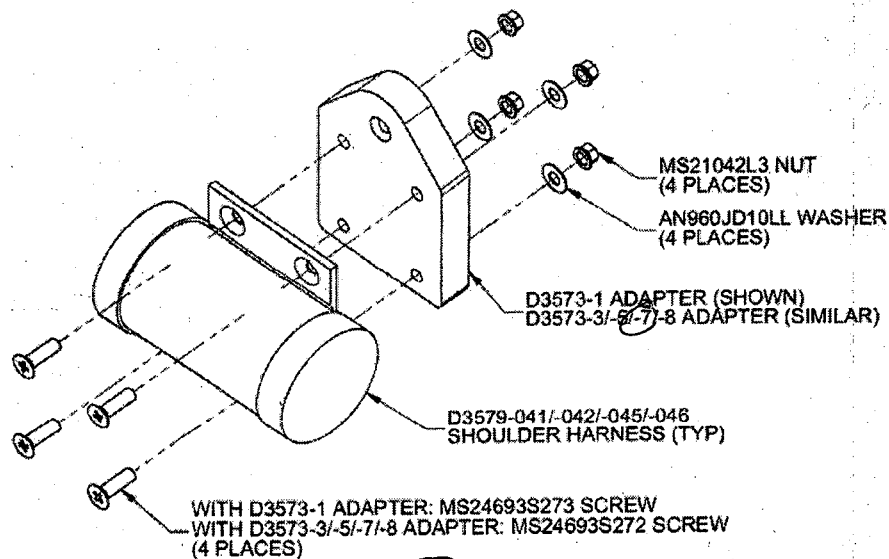
07/05/17

Job Completion

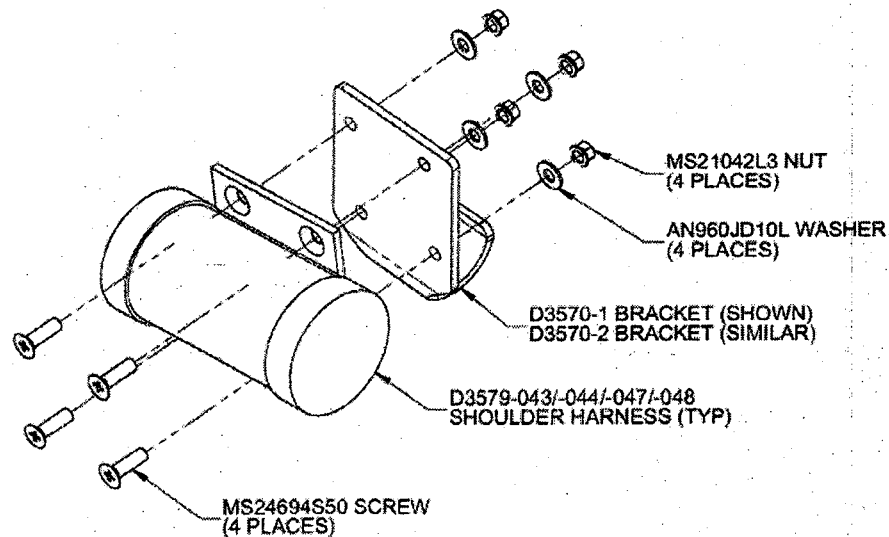


Inspection level 21

07/05/17



**DETAIL 'K' D412-702-101A/-103A/-105A/-107A/-109A/-115A/-117A AND  
D412-702-101B/-103B/-105B/-107B/-109B/-115B/-117B HARNESS ASSEMBLIES**  
(BELTS, K6.2 CLIP AND D3569-1/-2/-3 DECAL NOT SHOWN)



**DETAIL 'L' D412-702-111A/-111B/-113A/-113B HARNESS ASSEMBLIES**  
(BELTS AND D3569-1/-2/-3 DECALS NOT SHOWN)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32332

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| W/O:     |      | WORK ORDER CHANGES |    |          |     |                                     |                                |
|----------|------|--------------------|----|----------|-----|-------------------------------------|--------------------------------|
| DATE     | STEP | PROCEDURE CHANGE   | By | Date     | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector       |
| 07/05/17 | 1    | w/o split again    | ml | 07/05/17 | 2   | <i>[Signature]</i><br>07-05-17      | <i>[Signature]</i><br>07-05-17 |
|          |      |                    |    |          |     |                                     |                                |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 07/05/17  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |   |                |                                |                       |                                |
|----------|------|----------------------------------|--------------------------------|---|----------------|--------------------------------|-----------------------|--------------------------------|
| DATE     | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |   |                | Verification<br>Section C      | Approval<br>Chief Eng | Approval<br>QC Inspector       |
|          |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng   | Sign &<br>Date |                                |                       |                                |
| 07/05/17 | 8    | D3569-3<br>do not stick          | LE<br>07.05.17                 | Use contact cement<br><br>M102565<br><br>SEE ATTACHED EMAIL FROM<br>SCHROTH | ml<br>07/05/17 | <i>[Signature]</i><br>07-05-17 | LE<br>07.05.17        | <i>[Signature]</i><br>07-05-17 |
|          |      |                                  |                                |   |                |                                |                       |                                |
|          |      |                                  |                                |   |                |                                |                       |                                |

NOTE: Date & initial all entries

**Leanne Elsliger**

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**From:** Marianne Kump [Marianne.Kump@armorholdings.com]  
**Sent:** May 16, 2007 1:57 PM  
**To:** Leanne Elsliger  
**Subject:** FW: Crazy Glue on Buckle

*Marianne Kump*

Marianne Kump  
Engineering  
Schroth Safety Products  
(954) 784-3178 x 305  
(954) 784-3179 (fax)

---

**From:** Marianne Kump  
**Sent:** Wednesday, May 16, 2007 11:43 AM  
**To:** 'Leanne Elsliger'  
**Cc:** Jeff Schlueter; Jack Ziros  
**Subject:** FW: Crazy Glue on Buckle

Leanne,

Per our conversation this email is to approve the change of the temporary adhesive from "Krazy Glue" to LePaige Contact Cement LCP506.

All other details below still apply.

Best regards,

*Marianne Kump*

Marianne Kump  
Engineering  
Schroth Safety Products  
(954) 784-3178 x 305  
(954) 784-3179 (fax)

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**From:** Marianne Kump  
**Sent:** Wednesday, May 16, 2007 11:09 AM  
**To:** 'Leanne Elsliger'  
**Cc:** Jeff Schlueter; Jack Ziros  
**Subject:** RE: Crazy Glue on Buckle

Leanne,

Schroth Safety Products will allow the addition of the decal using "Krazy Glue" for the one shipment of restraints with SL 20 plastic buckles shipping today only. Schroth will not take responsibility for any failures of the housing due to the addition of the Krazy Glue to the plastic housing.

We will provide you with the name of a suitable bonding material in the near future so that DART can add the decal without voiding the restraint warranty.

Please note that under no circumstances does this email approve Krazy Glue to be used on and SL 36 buckles.

17/05/2007

Please provide part numbers and quantity of restraints in today's shipment will include so that we can add this information to our manufacturing file.

Best regards,

*Marianne Kump*

Marianne Kump  
Engineering  
Schroth Safety Products  
(954) 784-3178 x 305  
(954) 784-3179 (fax)

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**From:** Leanne Elsliger [mailto:lelsiger@dartaero.com]

**Sent:** Tuesday, May 15, 2007 4:01 PM

**To:** Marianne Kump

**Subject:** Crazy Glue on Buckle

Marianne – we'd like to have a decal adhered with crazy glue (edges only) to one side of the plastic buckle casing of SL 20 and SL36.L9/R9. Since the casing is not a structural component of the buckle, is this acceptable?

Thanks,  
Leanne

**Leanne Elsliger, P.Eng**  
Design Engineer  
Dart Aerospace Ltd.  
1270 Aberdeen St.  
Hawkesbury, ON, K6A 1K7  
T: (613) 632-5200  
F: (613) 632-9311

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17/05/2007